

Work Order ID 56234



Page 1

Wednesday, February 17, 2010 10:06:37 AM

Item ID:	D412-769-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Facing Seat, LH					
Start Date:	2/18/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/3/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MPF</u>	Date:	<u>10-2-17</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-769	Rev B

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-769-041		CHG 001	<u>S1066602</u>					

JG For BG 10/06/07

110		0.00							
	QC4- 100% Inspect kits for completeness								
QC	Memo	0.00							
Quality Control				<u>S1066607</u>					

x1 _____
41

120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-769-041								
	Location: _____								
	Rev: <u>B</u>								

PPP 56232

10-6-8 SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56234

Page 2

Wednesday, February 17, 2010 10:06:37 AM

Item ID: D412-769-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seat, LH

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/08

11-10-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 10:06:37 AM

Page 1

Work Order ID: 56234

Parent Item: D412-769-041

Parent Item Name: Aft Facing Seat, LH

Comments: IPP rev A 08-07-17 new issue DD verified by:EC

Start Date: 2/18/2010

Required Date: 3/3/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D412-724-041	CHC001	Manufactured	No			110	Each	0.0000	1.0000			
--------------	--------	--------------	----	--	--	-----	------	--------	--------	--	--	--



Head Rest Assembly, Center

D412-724-043	CHC001	Manufactured	No			110	Each	2.0000	1.0000			
--------------	--------	--------------	----	--	--	-----	------	--------	--------	--	--	--



Head Rest Assembly, LH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

44408

2

2

D412-769-043		Manufactured	No			110	Each	0.0000	1.0000			
--------------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Aft Facing Seat Assembly, LH

B5E275 10-6-7 SP

B5E260 10-6-7 SP

56234

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25.9 Parts List

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
1		1	D412-724-041	HEAD REST ASSY, CENTER
1		1	D3303-041	HEAD REST
1		1	D3304-041	TUBE ASSEMBLY
4		4	AN525-10R6	SCREW
1			D412-724-043	HEAD REST ASSY, LH
1			D3303-041	HEAD REST
1			D3304-043	TUBE ASSEMBLY
4			AN525-10R6	SCREW
		1	D412-724-044	HEAD REST ASSY, RH
		1	D3303-041	HEAD REST
		1	D3304-044	TUBE ASSEMBLY
		4	AN525-10R6	SCREW
1			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
2		2	D3782-045	BACK LEG ASSEMBLY
1		1	D3772-1	BACK LEG
1		1	D3786-1	SLEEVE
1		1	D3787-1	FOOT
1		1	D3764-1	BACK LEG ADAPTER
1		1	D3773-041	HEAD REST ADAPTER
1		1	AN5-15A	BOLT
1		1	AN45-15A	EYE BOLT
1		1	AN5-17A	BOLT
2		2	AN4-15A	BOLT
4		4	NAS1149D0463J	WASHER
5		5	NAS1149D0568J	WASHER
2		2	MS21042L4	NUT
3		3	MS21042L5	NUT
1		1	D3782-041	FRONT INBOARD LEG ASSEMBLY
1		1	D3768-1	FRONT INBOARD LEG
1		1	D3762-041	FRONT LEG FITTING ASSY
1		1	D3787-1	FOOT
1		1	AN5-13A	BOLT
3		3	NAS1149D0568J	WASHER
2		2	MS21042L5	NUT
1		1	AN45-13A	EYE BOLT
1			D3782-043	FRONT OUTBOARD LEG ASSEMBLY, LH
1			D3768-3	FRONT OUTBOARD LEG, LH
1			D3762-041	FRONT LEG FITTING ASSY
1			D3787-1	FOOT
2			AN45-13A	EYE BOLT
2			NAS1149D0568J	WASHER
2			MS21042L5	NUT

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

Revision: 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

ICA-D412-769
ICA Page 18 of 34

Qty -011	Qty -041	Qty -042	Part Number	Description
		1	D3782-044	FRONT OUTBOARD LEG ASSEMBLY, RH
		1	D3768-4	FRONT OUTBOARD LEG, RH
		1	D3762-041	FRONT LEG FITTING
		1	D3787-1	FOOT
		2	AN45-13A	EYE BOLT
		2	NAS1149D0568J	WASHER
		2	MS21042L5	NUT
	1	1	D3783-041	LATERAL BRACE ASSEMBLY
	1	1	D3769-1	TUBE
	2	2	D3765-1	CLEVIS
	2	2	AN5-13A	BOLT
	4	4	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	2	2	D3783-043	LONGITUDINAL BRACE ASSEMBLY
	1	1	D3769-3	TUBE
	1	1	D3765-1	CLEVIS
	1	1	AN5-13A	BOLT
	2	2	NAS1149D0568J	WASHER
	1	1	MS21042L5	NUT
	1	1	D3783-045	ANGLE BRACE ASSEMBLY
	1	1	D3769-5	TUBE
	2	2	D3765-1	CLEVIS
	2	2	AN5-13A	BOLT
	4	4	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	1	1	D3784-041	SEAT SUPPORT ASSEMBLY
	1	1	D3770-1	TUBE
	1	1	D3763-041	END FITTING ASSY
	1	1	D3763-045	END FITTING ASSY
	2	2	AN525-10R20	SCREW
	4	4	NAS1149D0332J	WASHER
	2	2	MS21042L3	NUT
	1	1	D3784-043	SEAT SUPPORT, LH
	1	1	D3762-043	END FITTING ASSY, LH
	1	1	D3770-1	TUBE
	1	1	D3770-3	TUBE
	2	2	D3763-041	END FITTING ASSY
	4	4	AN525-10R20	SCREW
	4	4	NAS1149D0332J	WASHER
	4	4	MS21042L3	NUT
	1	1	D3784-044	SEAT SUPPORT, RH
	1	1	D3762-044	END FITTING ASSY, RH
	1	1	D3770-1	TUBE
	1	1	D3770-3	TUBE
	2	2	D3763-041	END FITTING ASSY
	4	4	AN525-10R20	SCREW
	4	4	MS21042L3	NUT
	8	8	NAS1149D0332J	WASHER

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

Revision: 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD.
REFERENCE ONLY
ICA-D412-769
ICA Page 19 of 34

Qty -011	Qty -041	Qty -042	Part Number	Description
	1		D3766-1	FRONT RAIL, LH
		1	D3766-2	FRONT RAIL, RH
	1	1	D3766-3	REAR RAIL
	1	1	D3767-1	UPPER RAIL
	1	1	AN45-13A	EYE BOLT
	6	6	AN5-10A	BOLT
	2	2	AN5-13A	BOLT
	20	20	NAS1149D0568J	WASHER
	4	4	NAS1149D0463J	WASHER
	12	12	MS21042L5	NUT
	2	2	MS21042L4	NUT
	28	28	MS21042L3	NUT
	2	2	AN4-15A	BOLT
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH
	1	1	D3774-1	SEAT BOTTOM
	1	1	D3774-3	SEAT BACK
	13	13	AN525-10R22	SCREW
	9	9	AN525-10R24	SCREW
	21	21	NAS1149D0363J	WASHER
	13	13	NAS1149D0332J	WASHER
	6	6	AN3-5A	BOLT
	2	2	D3775-1	GUARD
	3	3	D3792.1	SEAT BELT EYE BOLT

NOTE: PART INCLUDED WITH ASSEMBLY ABOVE
PART INCLUDED WITH ASSEMBLY ABOVE
PART INCLUDED WITH ASSEMBLY ABOVE

• COPYRIGHT © 2008 BY DART AEROSPACE LTD •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

25-00-00

Revision: 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
			D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries